

# Work Order ID 69268

Friday, May 06, 2011 8:53:24 AM



Page 1

Item ID: D3852-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 5/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-11

Tooling:

Date:

Run: Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: 115928

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

SAD 11-05-08

PL 11-05-00

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69268**

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Setup Start



Revision ID:

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Item Name: Rib Assembly

Start Date: 5/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8 wks/24

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 wks/24

Quality Control

②

-042

150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

3AD

11-05-25

Packaging

②

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 5/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/2011

CL11105/25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, May 06, 2011 8:53:39 AM

Page 1

Work Order ID: 69268

Parent Item: D3852-042

Parent Item Name: Rib Assembly



Start Date: 5/6/2011

Required Date: 5/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3166-3		Manufactured	No			100	Each	3.0523	0.18	0.378947			
Basket Hoop													

Location

Loc Qty

Loc Code

WA007

3.05230527

64928

3.05230527

D3759-1		Manufactured	No			100	Each	206.0000	1	2			
Bushing													

Location

Loc Qty

Loc Code

WA005

206

66489

6

66870

200

SAD 11-05-08

0.3780

SAD 11-05-08

Cpl 11-05-0820

2

W/O:		WORK ORDER CHANGES						
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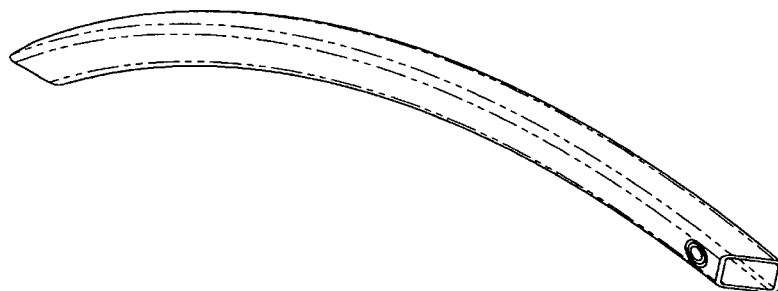


8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



**D3852-041 RIB ASSEMBLY**



**D3852-042 RIB ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 49268

*11-05-4*

RELEASE  
*08/11/07 MP*

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.83 lbs EACH  
8) WELDING: PER QSI 004

A	NEW ISSUE		MB	08.11.07
REV.		DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3852</b>  TITLE <b>RIB ASSEMBLY</b>  <b>COPYRIGHT © 2008 BY DART AEROSPACE LTD</b> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
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CHECKED				
MFG. APPR.				REV.
APPROVED				SHEET 1 OF 3
DE APPR.				SCALE
				NT
DATE	08.11.07			

8 7 6 5 4 3 2 1

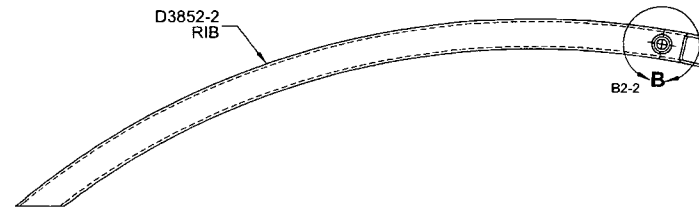
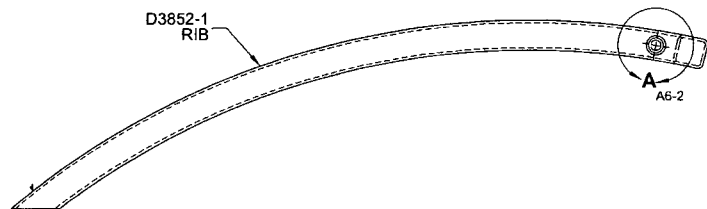
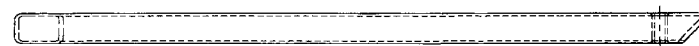
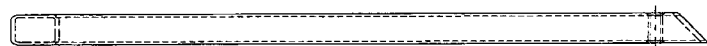
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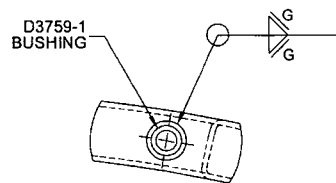
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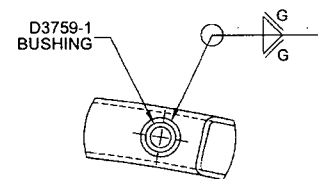


**D3852-041 RIB ASSEMBLY**

**D3852-042 RIB ASSEMBLY**



**DETAIL A**  
SCALE 2X C5-2



**DETAIL B**  
SCALE 2X C2-2

u/b 69268

**RELEASED**  
08/11/15

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	123	DRAWING NO.	REV. A
MFG. APPR.		<b>D3852</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSEMBLY</b>	NTS
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